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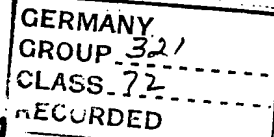
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JUN 1977

DEUTSCHES PATENTAMT



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Offenlegungsschrift**25 54 264**

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43747Y/25 M21 P52 Q32 OWEI 03.12.75
OWENS-ILLINOIS INC *DT 2554-264
03.12.75-DT-554264 (16.06.77) B21d-51/44 B65d-17/24
Metal cans with tear-off lids - where user is protected from the rough
edges formed when the can is opened

A metal closure is formed from a blank, consisting of a middle plate or lid and a projecting, peripheral edge section, by (a) forming an upper and lower ledge joined by a wall; (b) bending the outer edge of the lid to form a first loose loop (1); (c) scoring an endless separation line in the lower ledge; (d) bending the upper ledge and its adjacent wall to form a second loose loop (2); (e) folding loop (1) so that it butts against the lower ledge and forms a three-layer fold with a projecting nose; (f) fixing a tear-off tab on the lid, the tab having a nose extending to the separation line; and (g) folding loop (2) to overlap the separation line and the tab.

USE

For closing a container or can opened via a tear-off tab.

ADVANTAGES

Hands are shielded from the rough edge left on the can and the edge of the lid is smoothed over during its removal.

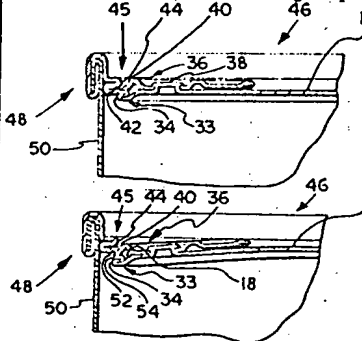
M(21-E1, 21-E4).

4 2

EMBODIMENT

After the forming operations, a closure (46) is provided with a double fold (48) on one end of a can (50), and the tear-off tab (36) has a nose (40) which partly overlaps the scored sepn. line (42) lying below the nose (44) of the cheek fold (45), i.e. the dia. of sepn. line (42) is larger than the bore formed by nose (44). Nose (40) is pressed downwards to produce fracture along sepn. line (42) so that lid (18) can

be removed to open can (50). Both sides (52, 54) of the fracture have a rough edge, but nose (44) covers edge (52), thus protecting the hand of the person opening the can. When tab (36) is lifted to remove lid (18), edge (54) on the lid is smoothed and polished by contact with nose (44). (17pp1144).



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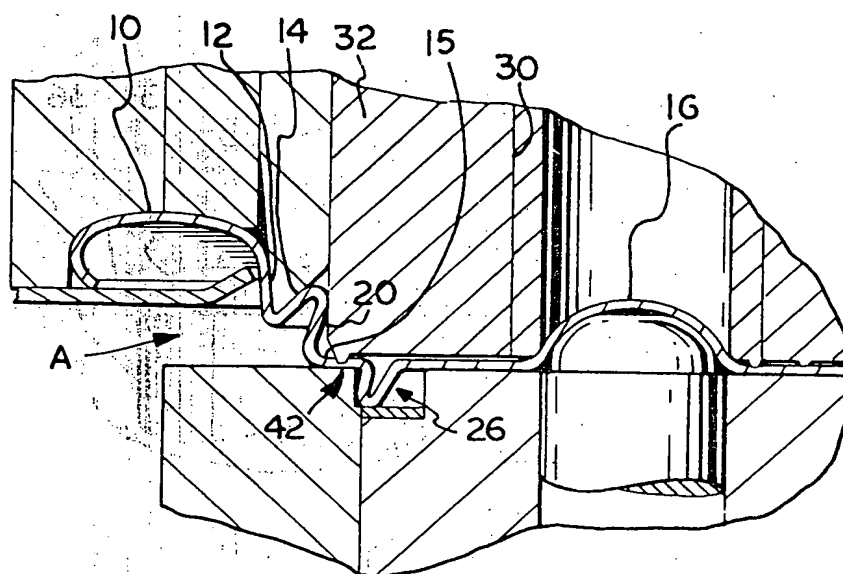


FIG. 3

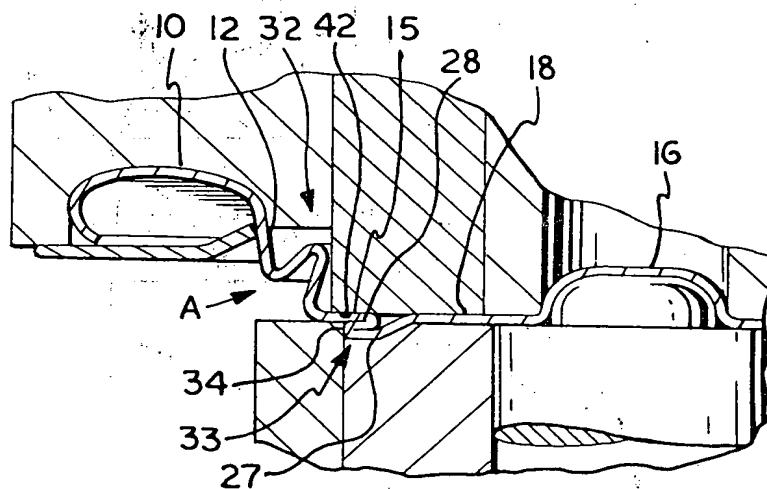


FIG. 4

15.

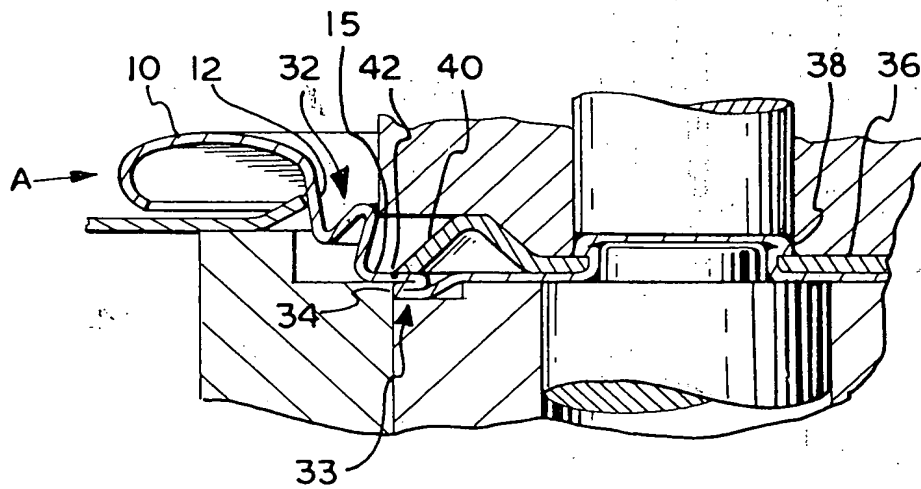


FIG. 5

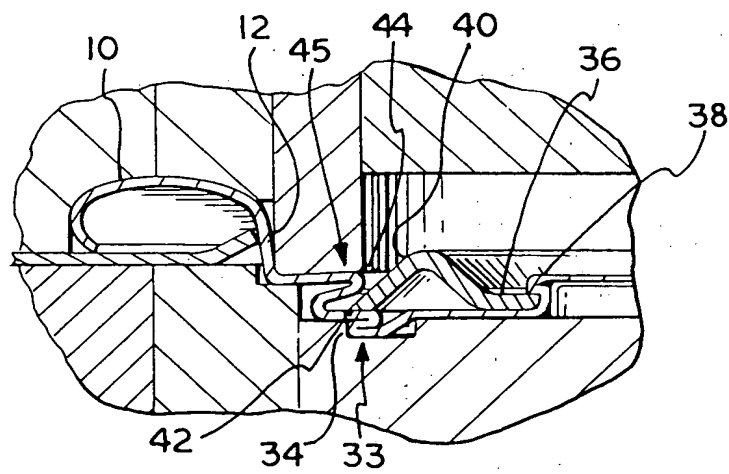


FIG. 6

16.

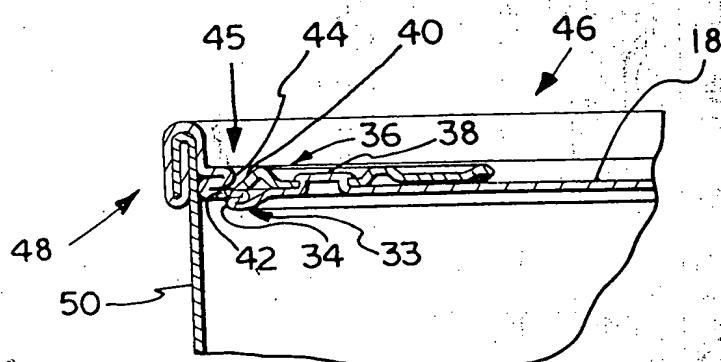


FIG. 7

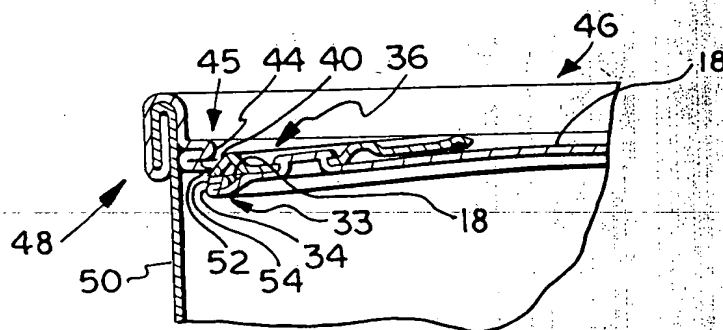


FIG. 8

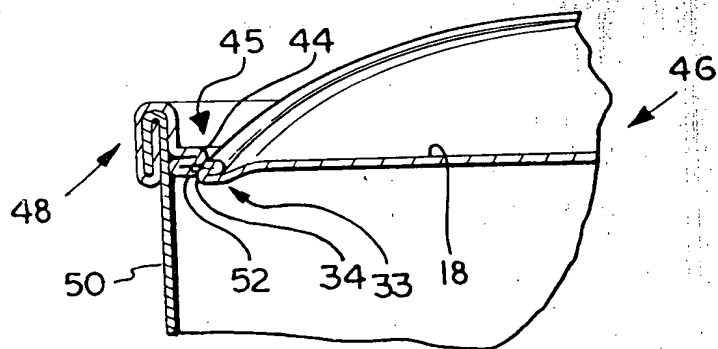


FIG. 9

-17-

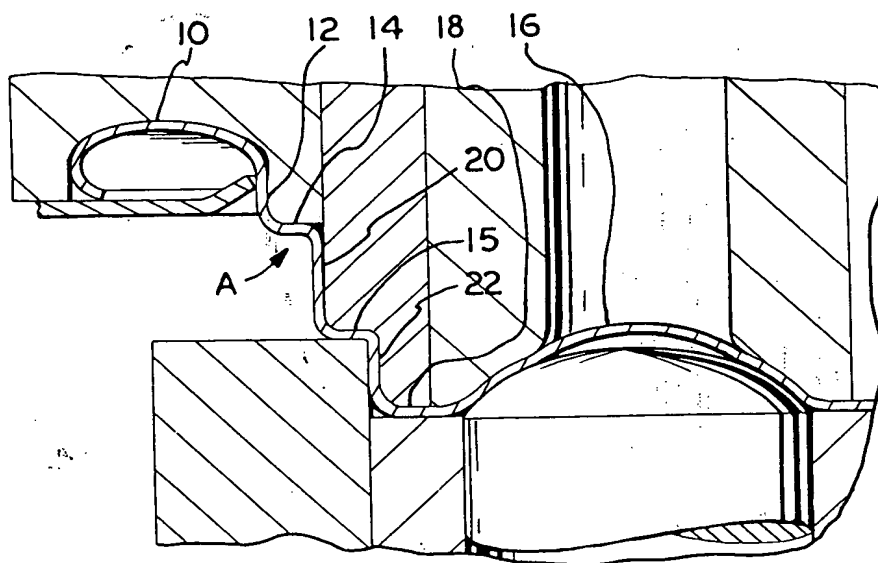


FIG. 1

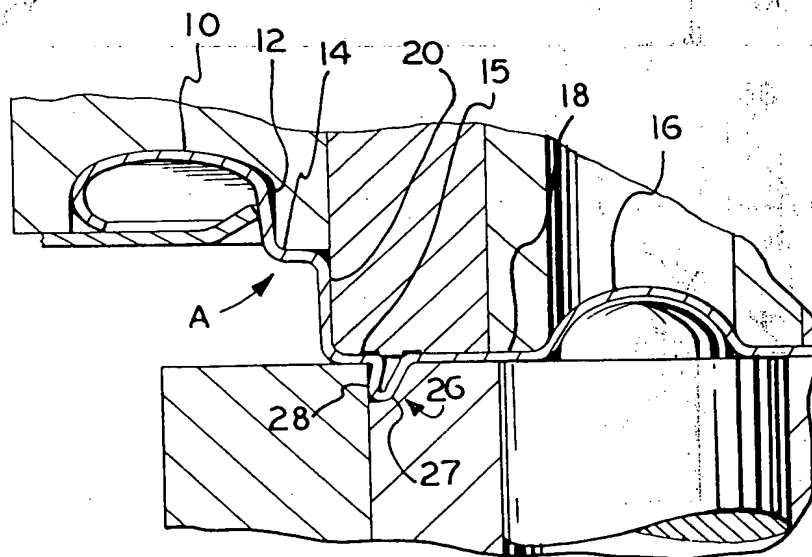


FIG. 2

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